

Tuesday, March 12, 2013 2:52:26 PM

Item ID: D3929-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gusset Assembly

Stop *NS2*

Start Date: 3/12/2013 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date: 13-03-12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Work Order ID 98531

98531

Page 2

Tuesday, March 12, 2013 2:52:26 PM

Item ID: D3929-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gusset Assembly

Start Date: 3/12/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch: <u>m122357</u>								
150	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

(6) 13-03-18 DAS
09
9-89
 (x6) mcl 13-03-20
 (6) 13-03-21 DAS
09
9-89

Work Order ID 98531

98531

Page 3

Tuesday, March 12, 2013 2:52:26 PM

Item ID: D3929-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gusset Assembly
 Start Date: 3/12/2013 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/19/2013 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				① 13-03-21			DAS 09
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA001</u> Memo	0.00 0.00				① 13-03-21			DAS 09
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/3/22 <i>[Signature]</i> CMF 13-3-21

Picklist Print

Tuesday, March 12, 2013 2:52:38 PM

Page 1

Work Order ID: 98531

98531

Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 3/12/2013

Required Date: 3/19/2013

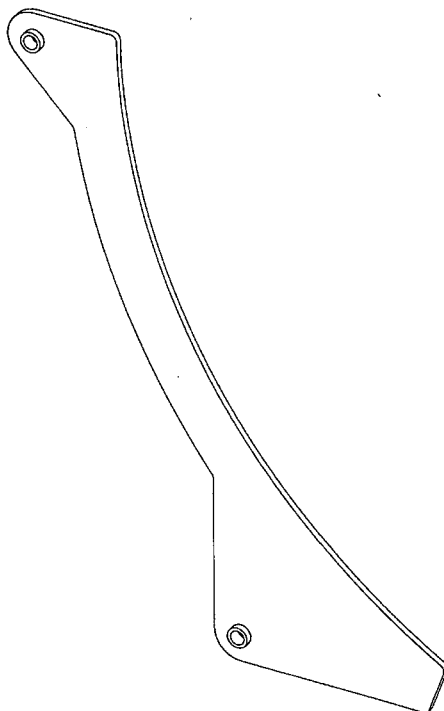
Start Qty: 6.00

Required Qty: 6.00

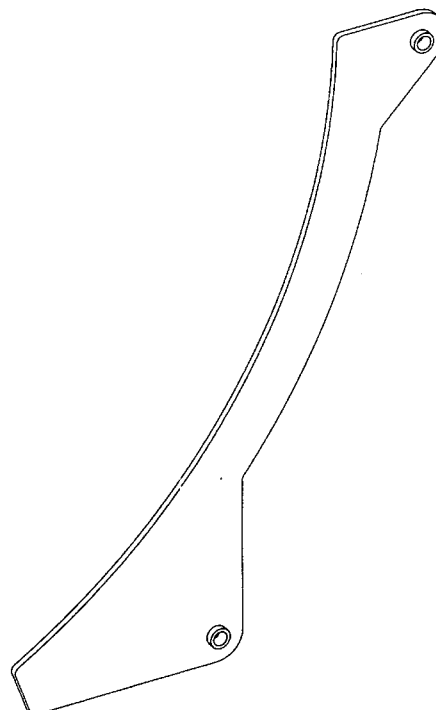
Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA *M304S11GA* 304/316 0.125 Sheet		Purchased	No			100	sf	258.0000	0.45	2.842105			
									**			W 13-03-15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				258					
				122521				66					
				24445				192					
D3907-1 *D3907-1* Bushing		Manufactured	No			130	Each	92.0000	2	12			
									**			(+12) ME 13-03-20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				52					
				88891				1					
				89688				1					
				95215				15					
				96302				35					
				WA007				40					
				96746				40					

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

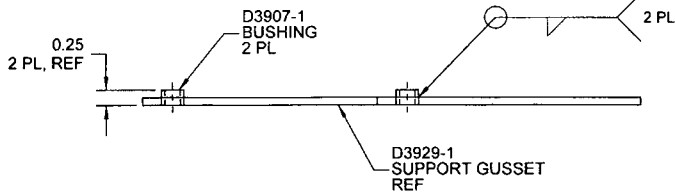
94531
13-03-12

RELEASED
8/10/12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3929	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		GUSSET ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.04.03		

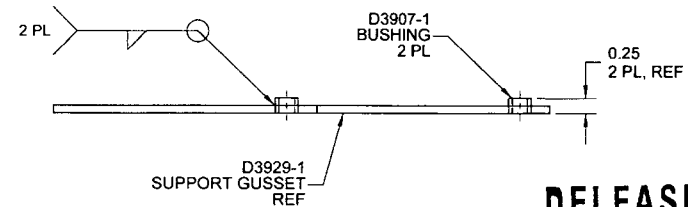
D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

98531

D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03	DRAWING NO. D3929	REV. A SHEET 2 OF 3
		TITLE GUSSET ASSEMBLY	SCALE NTS
COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

